

54390 Deren

Work Order ID 54134



Page 1

December 1, 2009 8:50:05 AM

Item ID: D3836-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 02/12/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 08/12/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start

Approvals: Process Plan: PL Date: 09-12-01 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3836	Rev A
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100

0.00



Large Fab

Large Fab

Memo

-0.00

Large Fab

1- cut D3836-1 and D3836-3 rib as per dwg D3836

2- remove identification markings

3- deburr

SAP 09-12-02

4- weld D3836-1 to D3836-3 and drill hole (3/16") using DT9447 jig and open to finish size as per dwg D3836

5- weld D2327-3 spacer bushing as per dwg D3836
A/R ER316 S.S. Rod Batch: M108175

6- grind weld flush where indicated on dwg

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

②

80 09. 12.

lpl 09/12/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 1, 2009 8:50:11 AM

Page 1

Work Order ID: 54134

Parent Item: D3836-041RevA

Parent Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 02/12/2009

Required Date: 08/12/2009

Comments: IPP rev B 09.11.24 updated process EC verified by:DD

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2327-3RevD

Manufactured

No

100

Each

18.0000

2.0000



Spacer Bushing

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

18

44274

5

44365

9

51126

4

M304TS0.750W.065

Purchased

No

100

f

509.7989

3.7491



304 SQ Tube .75x.75x.065W

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

509.7988742

113082

36.90419

113245

472.894684

Main Warehouse

WA

0.0000047

112398

0.0000047

SP 09-12-7.

2x

SAD 09-12-02

3.7491

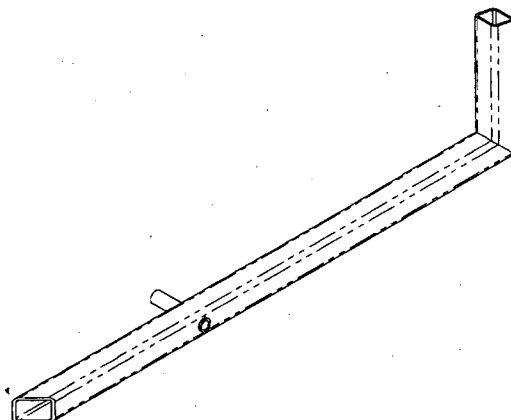
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

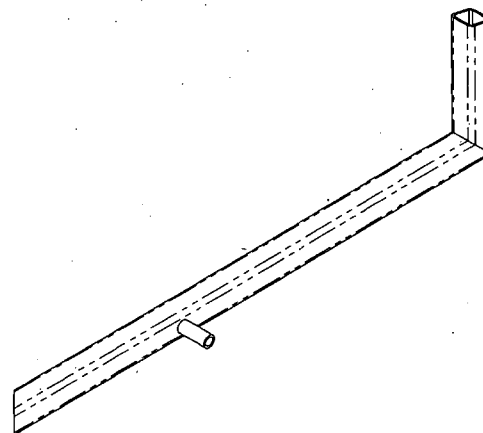
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3836-042 RIB ASSY (BASKET LID, RH)



D3836-041 RIB ASSY (BASKET LID, LH)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.99 lbs EACH
- 8) WELD PER DART QSI 004

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3836-041	RIB ASSY (BASKET LID, LH)
2		X	D3836-042	RIB ASSY (BASKET LID, RH)
3	1	1	D2327-3	SPACER BUSHING
4	1		D3836-1	RIB
5		1	D3836-2	RIB
6	1	1	D3836-3	RIB

SHOP COPY
RETURN TO
ENGINEER
UNCONTROLLED
SUBJECT TO APPROVAL
WITHOUT
WORK ORDER
NO. 54134
BT 09-12-01

RELEASED
[Signature]

1 A	NEW ISSUE	MB	08.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.24		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3836	REV. A
TITLE RIB ASSY (BASKET LID)	SHEET 1 OF 3
SCALE NTS	
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8

7

6

5

4

3

2

1

D

D

D3836-1
RIB

0.94

D2327-3
SPACER BUSHING

C

D3836-3
RIB6.00
REF

B

G

D3836-041 RIB ASSY (BASKET LID, LH)

A

8

7

6

5

4

3

2

1

0.94

D3836-2
RIBD2327-3
SPACER BUSHING

C

D3836-3
RIB6.00
REF

B

G

D3836-042 RIB ASSY (BASKET LID, RH)

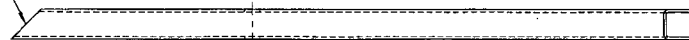
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08/11/14

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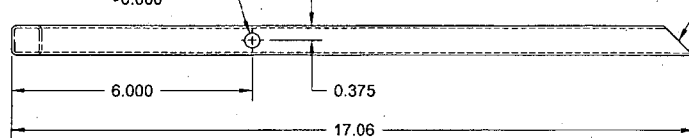
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3836	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
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CHAMFER



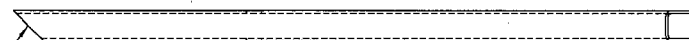
$\varnothing 0.375^{+0.020}_{-0.000}$ THRU

0.75 X 45°
CHAMFER



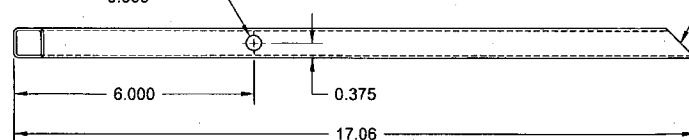
D3836-1 RIB

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CHAMFER

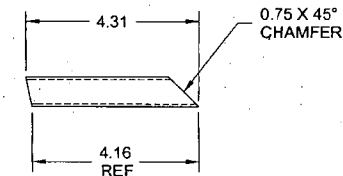


$\varnothing 0.375^{+0.020}_{-0.000}$ THRU

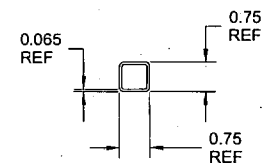
0.75 X 45°
CHAMFER



D3836-2 RIB



D3836-3 RIB



**TYPICAL SECTION
VIEW**

RELEASED
08/11/18

W/4 54134

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.		D3836	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
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